



WO# 2014-57

[illegible]

CARGO BASKET BODY FABRICATION - COMMON

2014-57

AS350 XL

x2

General

These instructions apply to all cargo basket body assemblies. Refer to the following drawings, at the current revision, for dimensions and details:

Bell 206L/407 – Right side only

69811, Revision 3 – Standard Low Mounted Basket

94511, Revision 0 – Extra-Wide Low Mounted Basket

94611, Revision 0 – Extra-Wide Low Mounted Ski Basket

76611, Revision 0 – High Mounted Ski Basket

Options 70404, Revision 2 – Front end cutout – 698

70411, Revision 0 – Front end cutout – 945/946

Eurocopter AS350/AS355 – left or right

77611, Revision 1 – Short Basket

76411, Revision 3 – Medium Basket (left or right)

78411, Revision 2 – Long Basket

→ 94011, Revision 0 – Extra Large (ski) Basket

Options 70406, Revision 2 – Front end cutout – 764/776/784/940

Robinson R44 – left or right

90611, Revision 0 – Standard Basket (left or right)

Bell 206B – right side only

80211, Revision 0 – Short Basket

80311, Revision 0 – Medium Basket

81111, Revision 0 – Long Basket

Options 70406, Revision 2 – Front end cutout – 802/803/811

Bell 429 – right or left

95911, Revision 0 – Standard Basket

Bell Medium – left or right

75111, Revision 0 – Standard Basket

95511, Revision 0 – Extra Large (ski) Basket

Options 70407, Revision 1 – Front end cutout – 751

704, Revision – Front end cutout – 955

MD600

82811, Revision 0 – Standard Basket

Options – Applicable to all models

70403, Revision 5 – Auxiliary Latch

CARGO BASKET BODY FABRICATION - COMMON

Complete
(initial or SCA #)

Work Order: 2014-57

#2 #1

Date Open: 25 July 2014

AD-05 AD-05

1. Rim Assembly – Basket Body

- a. Cut and fit $\frac{3}{4}$ " x 0.035 material to fit rim jig.
 - i. 1 or 2 lid prop bushing holes in short tube – refer to drawing
- b. Record material PO on attached material list.
- c. Remove writing on tubes with acetone and scotch bright.
- d. For extra large baskets – drill #30 (0.129) vent holes to vent stringer tubes into rims.
- e. 94611 (206L/407 XL ski) only – drill for 4 threaded bushings before assembling rim.

2. Weld Rim Assembly.

- a. Record welding rod PO on attached material list.
- b. 94611 (206L/407 XL ski) only – weld 4 threaded bushings into inboard rim tube.

AD-05 AD-05

3. Inspection

- a. Rim for complete welds

AD-05 AD-05

4. Frame assembly – body

- a. General
 - i. Vent holes shall be #30 (0.129), and located inside the structure wherever possible to allow venting of weld gasses through existing holes (i.e. lid prop bushing, hoops, etc.)
- b. Grind corner welds from step 2 on rim to allow hoops to sit flat.
- c. Pull required hoops from stock - standard, attachment, handle.
 - i. If hoops are not in stock see detailed procedure sheet for specific hoop fabrication.
 - ii. Ensure vent hole is located at centre of tube to vent spine tubes.
- d. Assemble hoops with attachment lug locating jig and hoop spacing jig.
 - i. Ensure correct order and orientation of hoops. Refer to drawing.
 1. Attachment lugs are on inboard side.
 2. Handle bracket bushings are on outboard side, second hoop from both ends.
May be on attachment hoops.
 - ii. Run 3/8-24 tap into attachment lugs to ensure clear threads.
 - iii. Bolt attachment lug locating jig to attachment hoops with 3/8-24 bolts.
 - iv. Attach inboard and outboard hoop spacing jigs to all hoops using 1" C-clamps. Raise jigs approximately 2" off table to allow room to weld around hoops.
 - v. Attach bottom (spine) jig to all hoops using 1" C-clamps along the centre line of the basket. Ensure jig is straight prior to tightening all clamps.
- e. Cut $\frac{1}{2}$ " x 0.035 material to fit spine jig.
- f. Cut $\frac{1}{2}$ " x 0.035 material for strut to fit from lower inboard attachment to upper outboard rim.
 - i. Refer to applicable drawing for position, not required on some baskets.
- g. Option: Cut $\frac{1}{2}$ " x 0.035 material for front end cutout. Record material PO on attached material list.
- h. 90611 (R44) only: Cut $\frac{1}{2}$ " x 0.035 material to fit front end structure. Record material PO on attached material list.
- i. Drill vent holes into attachment hoop and/or rim to vent strut(s) and front end cutout.

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CARGO BASKET BODY FABRICATION - COMMON

Complete
(initial or SCA #)

- j. Record hoop WOs and material POs on attached material list.
- k. Remove writing on tubes with acetone and scotch bright.
- l. Insert rim assembly into jig and set frame assembly onto rim. Ensure correct orientation of lid prop bushings in rim to frame. Bushing hole must be closer to attachment side.
- m. Align hoops to rim in accordance with drawing. General positions:
 - i. Extra large baskets
 - 1. inboard side of hoops (attachment side) aligns to OUTSIDE of rim
 - 2. outboard side of hoops (handle side) aligns to INSIDE of rim
 - 3. forward and aft hoops align to INSIDE of rim
 - ii. All other baskets
 - 1. inboard side of hoops (attachment side) aligns to INSIDE of rim
 - 2. outboard side of hoops (handle side) aligns to INSIDE of rim #2 #1
 - 3. forward and aft hoops align to INSIDE of rim, except R44

5. TIG weld frame to rim assembly.

AD-05 AD-05

- a. Ensure lug locating jig and hoop locating jigs are in place. Jigs must remain in place for as long as practical during welding.
- b. Strut tubes and front end cutout (see step 4.f. and g.) must be welded in place after the hoops are welded to the rim. Jig(s) must be in place prior to welding strut tubes.
- c. Robinson R44 (90611) requires fitting and welding of forward end after remainder of basket frame is welded. Use jig to support front hoop.
- d. Record welding rod PO on attached material list.

6. Inspection

AD-06 AD-06

- a. Frame assembly for complete welds.

7. Mesh assembly.

AD-06 AD-06

- a. Pull sheet of expanded mesh from stock. Record material PO on attached material list.
- b. Cut mesh to size for body.
- c. Remove surface rust with scotch-brite.
- d. Bend body mesh – use table with bend markings on top. Lock wheels on table.
 - i. For extra wide baskets only –
 - 1. Set $\frac{3}{4}$ " angle along edge of table under mesh sheet. Set 1.5" square tube on top of mesh aligned with angle on edge of table. Clamp in place with 6" C-clamps.
 - 2. Bend upper edge of sheet just past a cell intersection to make a flange 2.5" - 3.25" wide. Closer to 2.5" is preferred, full cell intersection on flange side at bend is required.
 - 3. Bend down by hand as far as possible, then use a hammer to flatten the bend tight against the angle on the edge of the table.
 - ii. Using markings on table, align sheet to indicated edge.
 - iii. Using markings on table, align 3" tube to required position and clamp tube in place.
 - iv. Bend mesh by hand tightly over tube along length of tube.
 - v. Keeping mesh in place, un-clamp 3" tube, move to other position and clamp tube in place.
 - vi. Bend mesh by hand tightly over tube along length of tube.
- e. Install attachment lug jig onto basket frame.

- f. Ensure end struts are welded in basket frame if required by the drawing.
- g. Insert mesh into basket.
 - i. General
 1. Some cells may interfere with correct positioning, especially at the upper corners and around struts. Bend cell(s) in as required, do not cut cells off.
 2. Ideally welds will be located on mesh intersections. Shift mesh if possible to minimize welds located off mesh intersections.
 3. Ensure mesh reaches all edges of basket BEFORE trimming. Regardless of progress in clamping, remove clamps and shift mesh if required.
 4. Ensure cleco clamps are placed from the inside of the basket to allow removal during welding. Cleco clamps may be used from the outside during fitting, but must be removed prior to welding.
 - ii. Extra large baskets only – seat corner of mesh with flange into inboard upper corner of frame. Use C-clamps on edge of flange as required to maintain tight fit.
 - iii. Starting at inboard top edge of basket, clamp mesh to hoop near top rim using cleco clamps onto hoops. For regular size baskets, edge of mesh should sit approximately half way up rim tube.
 - iv. Working down the inboard side, clamp mesh to hoops with cleco clamps. Clamp down into radius of hoop and continue clamping as required to maintain tight fit in corner of hoop. After the corners are tight, two clamps just onto the radius on both ends should be sufficient to hold the corner tight, remove all extra clamps.
 - v. Clamp mesh to spine in at least 1 place per section.
 - vi. Working up the outboard side, clamp the mesh into the radius of hoop and continue clamping as required to maintain tight fit in corner of hoop. After the corners are tight, 2 clamps just onto the radius on both ends should be sufficient to hold the corner tight, remove all extra clamps.
 - vii. Trim upper outboard edge of mesh if required, edge of mesh must be low enough on rim tube to prevent the weld from protruding above the edge of the rim. Some sheets are tapered and may require $\frac{1}{2}$ to 1 cell to be removed over some or all of the length of the basket. De-burr cut edges with a sanding disc on a die-grinder. Straighten cut cells with duck-bill pliers. Clamp mesh near upper edge to hoops with cleco clamps after trimming.
 - viii. Trim ends to land on hoops, at mesh intersections if possible.
- h. Cut mesh to fit ends. Record material PO on attached material list.
 - i. Remove surface rust with scotch-brite.
 - ii. Ensure mesh is cut at intersections where possible.
 - iii. Bend top edge of mesh 1/8"-3/16" down at 45 degrees
 - iv. Cut for front end cutout if required.
- i. 90611 (R44) only: Cut mesh to fit upper forward end. Record material PO on attached material list.
 - i. Remove surface rust with scotch-brite.
 - ii. Ensure mesh is cut at intersections where possible.
 - iii. Bend top edge of mesh 1/4" down at 60 degrees.
 - iv. Fit mesh to front end of basket.

CARGO BASKET BODY FABRICATION - COMMON

#2 #1
Complete
(initial or SCA #)
AD-05 AD-05

8. Weld mesh to frame assembly per drawing.
 - a. Ensure lug locating jig is in place prior to welding.
 - b. General welding requirements for all baskets, MIG welding:
 - i. Every intersection at top edges.
 - ii. Every intersection at ends.
 - iii. First 5 intersections down on hoops, then every second intersection.
 - iv. Every intersection along spine.
 - v. Extra large baskets – every intersection along corner.
 - vi. Every intersection around ends
 - vii. Every intersection along struts (if applicable)
 - c. Bend and trim cells bent in to fit mesh as required and weld in position.
 - d. Grind high spots off body mesh welds on ends before welding end mesh.
 - e. 90611 (R44) only – weld lid prop bushing (step 9) into rim BEFORE welding upper mesh on forward end of basket assembly.
 - f. Record welding rod PO on attached material list.

9. Weld basket components

- a. TIG weld lid prop bushing(s), one or two per drawing.
 - i. Record welding rod PO on attached material list.
 - ii. Record lip prop bushing WO on attached material list.
- b. TIG weld caps to close top of 1" hoops as applicable.
- c. 94611 (Bell206L/407 XL ski) only: cut rim over cross tube gap.
 - i. Cut inboard rim on aft end. Grind flush with hoops.
 - ii. TIG weld caps on open tubes.
 - iii. Record cap material PO on attached material list.
- d. 95911 (Bell 429) only: placard bracket to forward upper corner of basket.
 - i. Record welding rod PO on attached material list.
 - ii. Record placard bracket WO on attached material list.

AD-05 AD-05

10. Clean up

- a. Grind high spots off mesh welds.
- b. Tighten mesh using special pliers. Tighten enough to remove "oil canning", where mesh springs in or out. Do not tighten in corners of hoops, mesh will be deformed.
- c. Drill #9 through lid prop bushing(s). De-burr hole(s).
- d. Remove surface rust with scotch-brite pad.

AD-05 AD-05

11. Final Inspection

To be completed by a different person than the previous steps.

- a. Basket body assembly for complete welds, and required minimum mesh weld locations.
- b. Filled vent holes – usually on hoops
- c. Overall condition and conformity to drawing(s).
 - i. Hoops for height.
 - ii. Rim for width and length and alignment.
 - iii. Lid prop lugs in correct ends.
 - iv. Fore/aft strut in hoop if required by drawing.
- d. Material lists complete.

AD-05 AD-05

CARGO BASKET BODY FABRICATION - COMMON

Complete

(initial or SCA #)

- e. Tag complete basket body assembly in preparation for powder coating.

12. Powder Coating

- a. Parts are to be powder coated white in accordance with commercial practices.
- b. Record powder coating PO.
- c. Inspect powder coating on receiving.
- d. Tag basket body assembly and place into stock in preparation for assembly.

#2 #1
ADU ASB

CARGO BASKET LID FABRICATION - COMMON

2014-57

AS350 XL $\times 2$
w/ walkway

General

These instructions apply to all cargo basket lid assemblies. Refer to the following drawings, at the current revision, for dimensions and details:

Bell 206L/407 – Right side only

69812, Revision 3 – Standard Low Mounted Basket; Extra-Wide Low Mounted Basket

94612, Revision 0 – Extra-Wide Low Mounted Ski Basket

76612, Revision 0 – High Mounted Ski Basket

Eurocopter AS350/AS355 – left or right

77612, Revision 1 – Short Basket

69812, Revision 3 – Medium Basket (left and right)

78412, Revision 2 – Long Basket

→ 94012, Revision 0 – Extra Large (ski) Basket

Robinson R44 – left or right

90612, Revision 0 – Standard Basket (left or right)

Bell 206B – right side only

80212, Revision 0 – Short Basket

80312, Revision 0 – Medium Basket

81112, Revision 0 – Long Basket

Bell 429 – right or left

95912, Revision 0 – Standard Basket

Bell Medium – left or right

75112, Revision 0 – Standard Basket

95512, Revision 0 – Extra Large (ski) Basket

MD600

82812, Revision 0 – Standard Basket

Options

→ 70405, Revision 3 – Walkway

70402, Revision 1 – Lid Door

CARGO BASKET LID FABRICATION

Complete
(initial or SCA #)

Work Order: 2014-57

#2 #1

Date Open: _____

1. Rim Assembly – Basket Lid

- Cut and fit $\frac{3}{4}$ " x 0.035 material to fit rim jig, 45 degree ends.
 - 1 or 2 lid prop bushing holes in short tube – refer to drawing
- Record material PO on attached material list.
- Remove writing on tubes with acetone and scotch bright.

A006 A006

2. Weld Rim Assembly

- Record welding rod PO on attached material list.

AD-05 AD-05

3. Inspection

- Rim for complete welds

A006 A006

4. Frame assembly – Lid

- General
 - Vent holes shall be #30 (0.129), and located inside the structure wherever possible to allow venting of weld gasses through existing holes (i.e. lid prop bushing)
- Insert rim from step 2 into jig.
- Cut and fit $\frac{3}{4}$ " x 0.035 material, 21" long, for lid cross members.
- Record material PO on attached material list.
- Remove writing on tubes with acetone and scotch bright.
- Drill vent holes into rim to vent cross members into rim.
- Locate cross members in lid rim. Refer to drawing for spacing of cross members. Clamp cross members with C-clamps to jig.

A006 A006

5. Frame assembly – Lid with optional walkway modification

- Fit cross members to rim in accordance with step 4.
- Attach walkway jig with C-clamps. Ensure correct orientation of rim, refer to drawing.
- Cut $\frac{1}{2}$ " x 0.035 material for walkway stringers to fit between lid cross members. Record material PO on attached material list.
- Drill vent holes into cross members at walkway stringers.
- Align walkway stringers on walkway jig using cleco clamps near both ends of each stringer, and clamp stringer to jig using a C-clamp in the centre.

A106 A006

6. Weld frame assembly.

- Record welding rod PO on attached material list.
- Jigs must remain in place for as long as practical during welding.

AD-05 AD-05

7. Inspection

- Frame assembly for complete welds.

A006 A006

CARGO BASKET LID FABRICATION

#2 #1
Complete
(initial or SCA #)

8. Mesh assembly.

Note: 95912 (Bell 429) does not have mesh. Skip to step 10.

- Pull sheet of expanded mesh from stock. Record material PO on attached material list.
- Cut mesh to size for lid.
- Remove surface rust with scotch-brite.
- Ensure lid is prepared for mesh on the correct side.

9. Weld mesh to frame assembly per drawing.

- General welding requirements for all lids:
 - Every intersection on all edges.
 - First 5 intersections along cross members, then every second intersection.
- MIG weld both short sides.
- Clamp lid over spacer at centre of lid to pre-tension mesh.
 - $\frac{3}{4}$ " for lids under 76"
 - 1" (check) for lids over 76"
- Weld remainder of mesh as indicated in a.
- Record welding rod PO on attached material list.

10. Weld lid components.

- Handle brackets, locate in accordance with drawing.
 - Standard location: $\frac{1}{4}$ " outside of last cross member on both ends.
 - Record handle bracket WO and welding rod PO on attached material list.
- Lid prop bushing(s).
 - one or two in accordance with drawing.
 - Record lip prop bushing WO and welding rod PO on attached material list.
- Placard bracket. – not installed on 95912 (Bell 429)
 - Locate on cross member to set bracket in centre bay of lid.
 - Record placard bracket WO and welding rod PO on attached material list.

11. Clean up

- Grind high spots off mesh welds.
- Tighten mesh using special pliers. Tighten enough to remove "oil canning", where mesh springs in or out.
- Straighten lid using frame attached under welding table. Work carefully, avoid excessive force to prevent kinking rim tubes.
- Drill #9 through lid prop bushing(s). De-burr hole(s).
- Drill for lid bumpers using $\frac{1}{4}$ " (#3) centre drill.
 - 3 places for lids under 76"
 - 4 places for lids over 76"
- Remove surface rust with scotch-brite pad.

12. Final Inspection

To be completed by a different person than the previous steps.

- Basket lid assembly for complete welds, and required minimum mesh weld locations.
- Material lists complete.
- Overall condition and conformity to drawing(s).

CARGO BASKET LID FABRICATION

#2 #1

Complete

(initial or SCA #)

NOG AO

13. Powder Coating

- a. Parts are to be powder coated white in accordance with commercial practices.
- b. Record powder coating PO.
- c. Inspect powder coating on receiving.
- d. Tag lid assembly and place into stock in preparation for assembly.

Work Order: 2014-57Date Opened: 25 July 2014

Material Tracking Sheet
Eurocopter AS350 / AS355
Extra Large Basket Body Fabrication

1 of 2

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
		94011	94011-01	Basket Assembly		
Step 1				<i>Rim Assembly</i>		
	. 2		--	3/4" Tube - Long Rim (97")	4130 Steel, 3/4" x 0.035 Sqr. Tube	14009
	. 2		--	3/4" Tube - Short Rim (25.5")	4130 Steel, 3/4" x 0.035 Sqr. Tube	13087
	. 1		--	3/4" Tube - Long Stringer (95.5")	4130 Steel, 3/4" x 0.035 Sqr. Tube	14009
	. 4		--	3/4" Tube - Short Stringer (2.25")	4130 Steel, 3/4" x 0.035 Sqr. Tube	+212312 1211
Step 2				<i>Weld Rim Assembly</i>		
	. A/R		--	Welding Rod	ER70S-2 TIG Rod	PO# 14005
Step 3				<i>Inspection - Rim</i>	None	
Step 4				<i>Frame Assembly</i>		
	. 4		94030-01	Hoop - standard	4130 Steel, 1/2" x 0.035 Sqr. Tube	2014-36
	. 2		94023-01	Hoop - attachment		2011-30
	. 5		--	1/2" Tube - spine	4130 Steel, 1/2" x 0.035 Sqr. Tube	14009
Step 4.g.		70406	70406-01	<i>Option: Front End Cutout</i>		
			70406-03	1/2" Tube	4130 Steel, 1/2" x 0.035 Sqr. Tube	
			70406-04	1/2" Tube	4130 Steel, 1/2" x 0.035 Sqr. Tube	
Step 5				<i>Weld Frame Assembly</i>		
	. A/R		--	Welding Rod	ER70S-2 TIG Rod	PO# 14005
Step 6				<i>Inspection - Frame Assembly</i>	None	
Step 7				<i>Mesh Assembly</i>		
	. 1		--	Mesh (Body - 56" x 96")	3/4-16F Expanded Mild Steel sheet	14012
	. 2		--	Mesh (End - 25" x 18")	3/4-16F Expanded Mild Steel sheet	14012

Work Order: 2014-57Material Tracking Sheet
Eurocopter AS350 / AS355
Extra Large Basket Body Fabrication

2 of 2

Date Opened: 25 July 2014

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
Step 8				<i>Weld Mesh</i>		
	. A/R		--	Welding Rod	ER70S-6 MIG Wire	PO # 14005
Step 9				<i>Weld Basket Components</i>		
	. 2		49215-01	Spacer (Lid prop)	304 Stainless Steel, ½" Dia.	PO # 2014-39
	. A/R		--	Welding Rod	ER308L TIG Rod	PO # 14028
Step 10				<i>Clean Up</i>	None	
Step 11				<i>Inspection - Final Assembly</i>	None	
Step 12				<i>Powder Coating</i>		

Work Order: 2014-57Material Tracking Sheet
Eurocopter AS350 / AS355
Extra Large Lid Fabrication

1 of 2

Date Opened: 25 July 2014

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
		94012	94012-01	Lid Assembly		
Step 1				Rim Assembly		
	. 2		--	3/4" Tube - Long Rim (97")	4130 Steel, 3/4" x 0.035 Sqr. Tube	14009
	. 2		--	3/4" Tube - Short Rim (22.5")	4130 Steel, 3/4" x 0.035 Sqr. Tube	13081
Step 2				Weld Rim Assembly		
	. A/R			Welding Rod	ER70S-2 TIG Rod	PO# 14005
Step 3				Inspection - Rim	None	
Step 4				Frame Assembly		
	. 4		--	3/4" Tube - Cross Member (21")	4130 Steel, 3/4" x 0.035 Sqr. Tube	12123 / 14009
Step 5		70405		Option: Frame Assembly - with walkway		
	. 10		--	1/2" Tube - walkway	4130 Steel, 1/2" x 0.035 Sqr. Tube	14009
Step 6				Weld Frame Assembly		
	. A/R			Welding Rod	ER70S-2 TIG Rod	PO# 14005
Step 7				Inspection - Frame Assembly	None	
Step 8				Mesh Assembly		
	. 1		--	Mesh (lid - 96" x 22")	3/4-16F Expanded Mild Steel sheet	14012
Step 9				Weld Mesh		
	. A/R			Welding Rod	ER70S-6 MIG Wire	PO# 14005

Work Order: 2014-57Material Tracking Sheet
Eurocopter AS350 / AS355
Extra Large Lid Fabrication

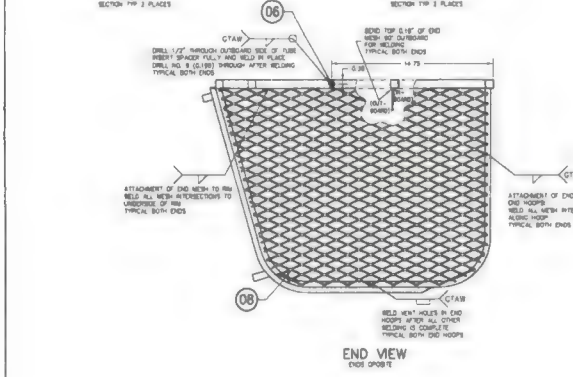
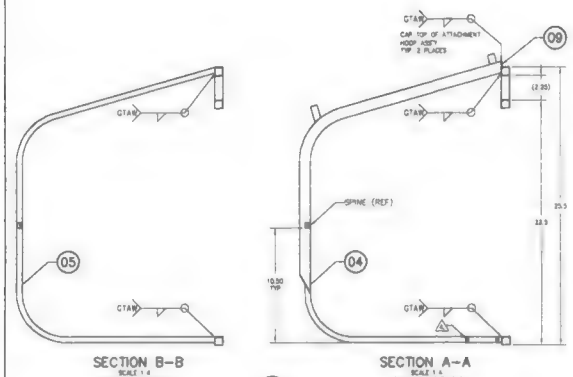
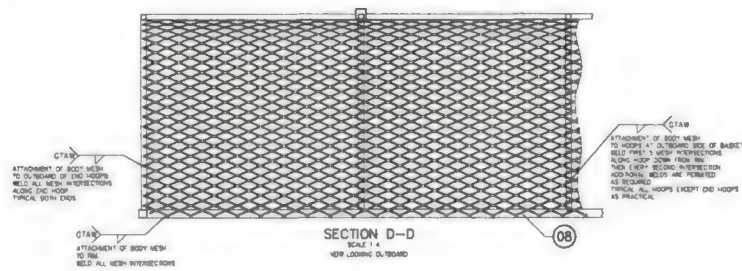
2 of 2

Date Opened: 25 July 2014

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
Step 10				<i>Weld Lid Components</i>		
	. 1	84262	84262-01	Upper Handle Bracket Assembly		WO # 2014-30
	. . 4		36273-01	Lid Bracket	321 Stainless, 0.050 Sheet	
	. . 2		36275-02	Support	304 Stainless, 5/16" Rod	
	. A/R			Welding Rod	ER308L TIG Rod	PO # 14005
	. 2		49216-01	Spacer (Lid prop)	304 Stainless, 1/2" Dia.	WO # 2014-09
	. A/R			Welding Rod	ER308L TIG Rod	PO # 14005
	. 1		36204-10	Placard Bracket	1018 Steel, 0.035" Sheet	WO # 2014-18
	. A/R			Welding Rod	ER70S-2 TIG Rod	PO # 14005
Step 11				<i>Clean Up</i>		
Step 12				<i>Inspection - Final Assembly</i>		
Step 13				<i>Powder Coating</i>		

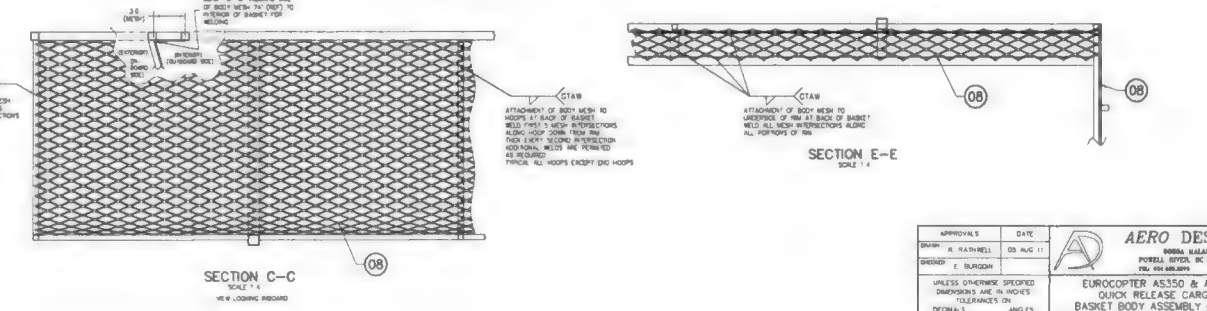
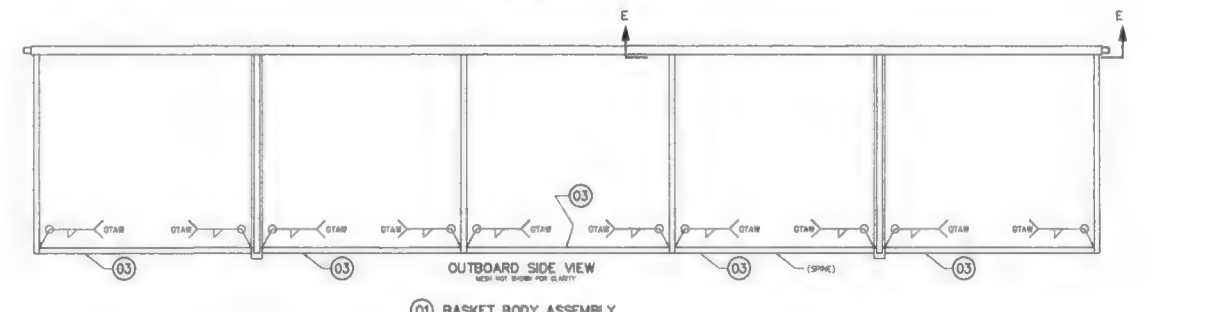
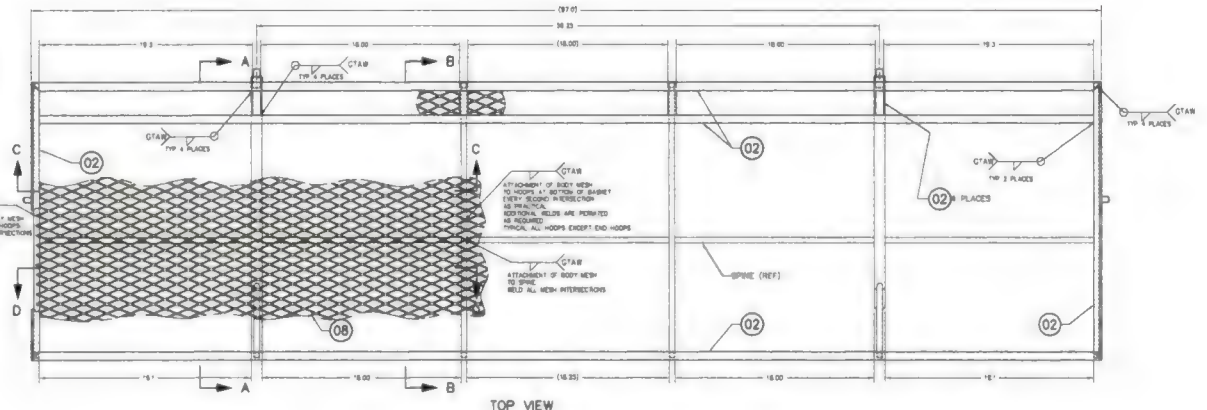
2014-57

REV	DESCRIPTION OF CHANGE	INITIALS	DATE
1	FILE BOOK UPDATED: WELDING ROD UPDATES REFERENCED UNCS ADDED	BAC	11/27/2014
2	FILE BOOK UPDATED: WELDING ROD UPDATES REFERENCED UNCS ADDED		
3	FILE BOOK UPDATED: WELDING ROD UPDATES REFERENCED UNCS ADDED		



- NOTES
1. REMOVE ALL BURRS AND BREAK SHARP EDGES
 2. PRIOR TO WELDING, DRILL AND (0.125) VENT HOLES IN ASSEMBLY FOR VENTING OF GASES WHEN ASSEMBLY IS COMPLETE. FILL ALL EXPOSED VENT HOLES WITH MOTEITE WELD
 3. WELDING OF 4340 STEEL TO BE COMPLETED BY CTAW METHOD TO 4340/2400
 4. 30 AND 1018 STEEL WELDING ROD SHALL CONFORM TO EN100-2 OR EQUIVALENT
 5. 30 AND 1018 STEEL WELDING ROD SHALL CONFORM TO 1300B OR EQUIVALENT
 6. INSTALL TEN (10) BARBET HANDLE PROVISIONS ASSEMBLY IN ACCORDANCE WITH AERO DESIGN LTD DRAWING 84822 BEFORE WELDING HOOPS TO RIB
 7. FINISH THOROUGHLY CLEAN AND POWDER COAT BASKET ASSEMBLY

QTY	PART NO	NAME	DESCRIPTION	MATERIAL	QTY	UNIT
1	08	CAP	WELD STEEL	4340/2400	1	0850 BASKET
1	09	01	08 MESH	WELD STEEL	COMMON	
1	09	02	01	08 MESH	COMMON	
1	09	03	01	08 MESH	COMMON	
1	09	04	01	08 MESH	COMMON	
1	09	05	01	08 MESH	COMMON	
1	09	06	01	08 MESH	COMMON	
1	09	07	01	08 MESH	COMMON	
1	09	08	01	08 MESH	COMMON	
1	09	09	01	08 MESH	COMMON	
1	09	10	01	08 MESH	COMMON	
1	09	11	01	08 MESH	COMMON	
1	09	12	01	08 MESH	COMMON	
1	09	13	01	08 MESH	COMMON	
1	09	14	01	08 MESH	COMMON	
1	09	15	01	08 MESH	COMMON	
1	09	16	01	08 MESH	COMMON	
1	09	17	01	08 MESH	COMMON	
1	09	18	01	08 MESH	COMMON	
1	09	19	01	08 MESH	COMMON	
1	09	20	01	08 MESH	COMMON	

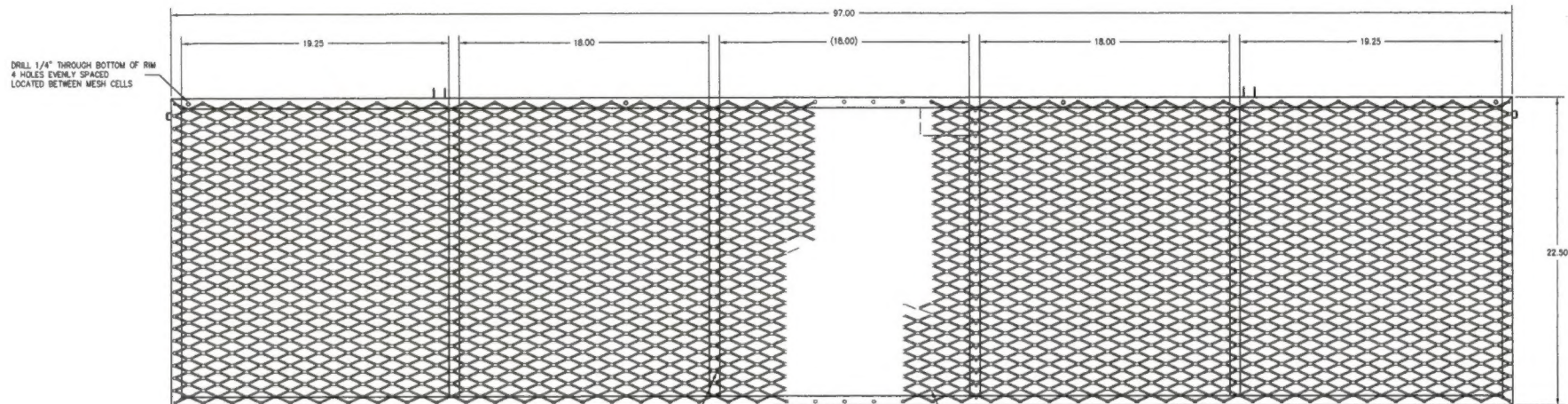


SECTION E-E
SCALE 1:4

APPROVALS	DATE	REVISION	DESCRIPTION
DESIGNED BY: E. BUSHNELL	03 AUG 11	1	0850 BASKET
DESIGNED BY: E. BUSHNELL	03 AUG 11	2	0850 BASKET
DESIGNED BY: E. BUSHNELL	03 AUG 11	3	0850 BASKET
DESIGNED BY: E. BUSHNELL	03 AUG 11	4	0850 BASKET
DESIGNED BY: E. BUSHNELL	03 AUG 11	5	0850 BASKET
DESIGNED BY: E. BUSHNELL	03 AUG 11	6	0850 BASKET
DESIGNED BY: E. BUSHNELL	03 AUG 11	7	0850 BASKET
DESIGNED BY: E. BUSHNELL	03 AUG 11	8	0850 BASKET
DESIGNED BY: E. BUSHNELL	03 AUG 11	9	0850 BASKET
DESIGNED BY: E. BUSHNELL	03 AUG 11	10	0850 BASKET
DESIGNED BY: E. BUSHNELL	03 AUG 11	11	0850 BASKET
DESIGNED BY: E. BUSHNELL	03 AUG 11	12	0850 BASKET
DESIGNED BY: E. BUSHNELL	03 AUG 11	13	0850 BASKET
DESIGNED BY: E. BUSHNELL	03 AUG 11	14	0850 BASKET
DESIGNED BY: E. BUSHNELL	03 AUG 11	15	0850 BASKET
DESIGNED BY: E. BUSHNELL	03 AUG 11	16	0850 BASKET
DESIGNED BY: E. BUSHNELL	03 AUG 11	17	0850 BASKET
DESIGNED BY: E. BUSHNELL	03 AUG 11	18	0850 BASKET
DESIGNED BY: E. BUSHNELL	03 AUG 11	19	0850 BASKET
DESIGNED BY: E. BUSHNELL	03 AUG 11	20	0850 BASKET

APPROVALS	DATE	REVISION	DESCRIPTION
DESIGNED BY: E. BUSHNELL	03 AUG 11	1	0850 BASKET
DESIGNED BY: E. BUSHNELL	03 AUG 11	2	0850 BASKET
DESIGNED BY: E. BUSHNELL	03 AUG 11	3	0850 BASKET
DESIGNED BY: E. BUSHNELL	03 AUG 11	4	0850 BASKET
DESIGNED BY: E. BUSHNELL	03 AUG 11	5	0850 BASKET
DESIGNED BY: E. BUSHNELL	03 AUG 11	6	0850 BASKET
DESIGNED BY: E. BUSHNELL	03 AUG 11	7	0850 BASKET
DESIGNED BY: E. BUSHNELL	03 AUG 11	8	0850 BASKET
DESIGNED BY: E. BUSHNELL	03 AUG 11	9	0850 BASKET
DESIGNED BY: E. BUSHNELL	03 AUG 11	10	0850 BASKET
DESIGNED BY: E. BUSHNELL	03 AUG 11	11	0850 BASKET
DESIGNED BY: E. BUSHNELL	03 AUG 11	12	0850 BASKET
DESIGNED BY: E. BUSHNELL	03 AUG 11	13	0850 BASKET
DESIGNED BY: E. BUSHNELL	03 AUG 11	14	0850 BASKET
DESIGNED BY: E. BUSHNELL	03 AUG 11	15	0850 BASKET
DESIGNED BY: E. BUSHNELL	03 AUG 11	16	0850 BASKET
DESIGNED BY: E. BUSHNELL	03 AUG 11	17	0850 BASKET
DESIGNED BY: E. BUSHNELL	03 AUG 11	18	0850 BASKET
DESIGNED BY: E. BUSHNELL	03 AUG 11	19	0850 BASKET
DESIGNED BY: E. BUSHNELL	03 AUG 11	20	0850 BASKET

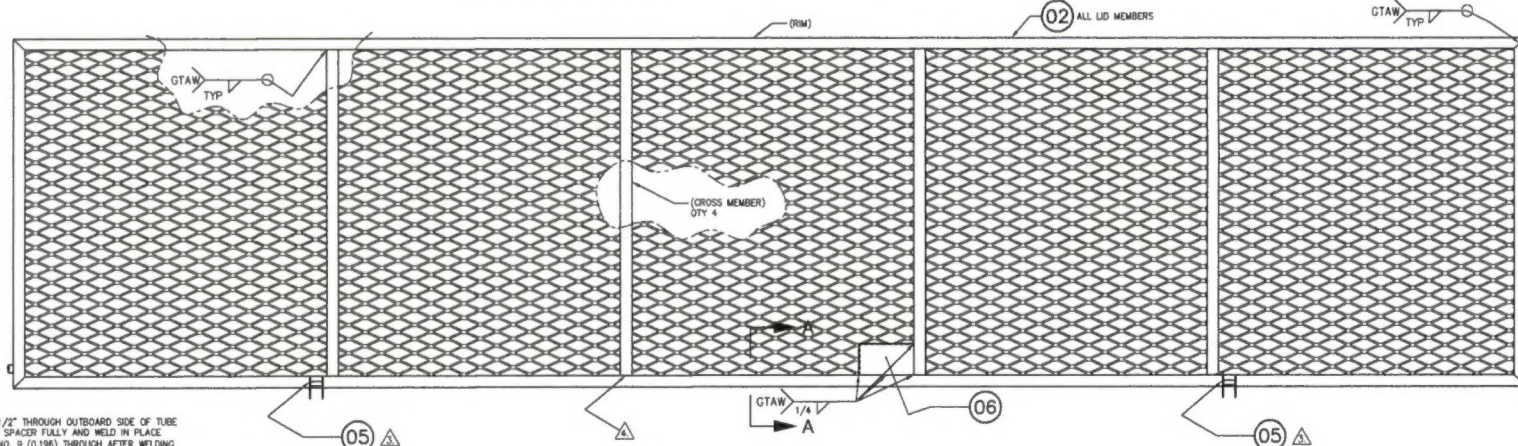
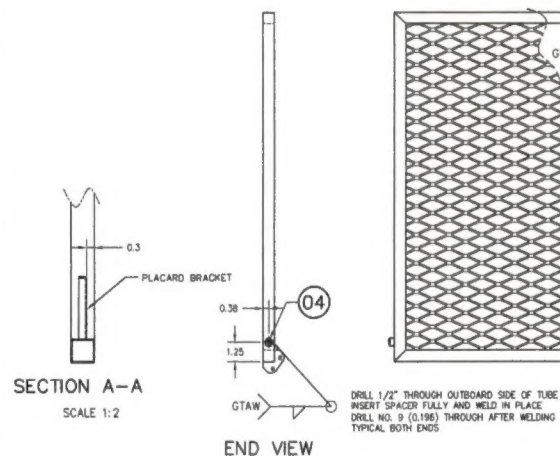
THIS DRAWING CONTAINS INFORMATION AND DATA WHICH IS PROPRIETARY TO AERO DESIGN LTD. THIS DRAWING OR ANY PORTION THEREOF, MAY NOT BE REPRODUCED, COPIED, OR EMULATED IN ANY MANNER, NOR USED FOR MANUFACTURING WITHOUT THE WRITTEN CONSENT OF AERO DESIGN LTD. BY ACCEPTING THIS DRAWING FOR REFERENCE, THE RECIPIENT AGREES TO HOLD AERO DESIGN LTD. HARMLESS FROM THE USE, OR MISUSE, OF THIS DRAWING OR THE INFORMATION CONTAINED THEREIN.			
REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	TITLE BLOCK UPDATED: CHANGED 36273-01 TO 84263-01; ITEM #S ADDED	BUC	10/07/2014
	WELDING ROD UPDATED: # OF WELDS DOWN BRACE TUBES INCREASED		



GTAW TYP
ATTACHMENT OF MESH TO RIM: WELD EACH INTERSECTION

GTAW TYP
ATTACHMENT OF MESH TO CROSS MEMBERS: WELD FIRST FIVE INTERSECTIONS THEN EVERY SECOND INTERSECTION. ADDITIONAL WELDS ARE PERMITTED AS REQUIRED

BOTTOM VIEW 03 MESH



TOP VIEW

01 LID ASSEMBLY

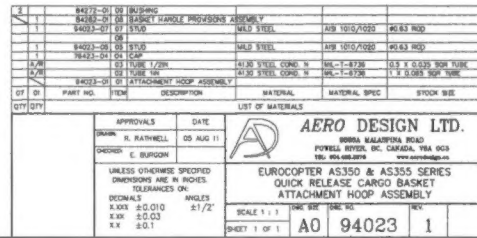
- NOTES:
- REMOVE ALL BURRS AND BREAK SHARP EDGES.
 - WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AMS 2685C. 4130 AND 1018 STEEL: WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT. STAINLESS AND 4130 STEEL: WELDING ROD SHALL CONFORM TO ER308L OR EQUIVALENT.
 - INSTALL ITEM 5 (LID HANDLE PROVISIONS ASSEMBLY) IN ACCORDANCE WITH AERO DESIGN LTD. DRAWING 84263.
 - DRILL #30 (0.129) HOLES IN LONG TUBE MEMBERS AT BRACE LOCATIONS TO VENT WELD GASSES. WHEN ASSEMBLY IS COMPLETE, FILL ALL EXPOSED VENT HOLES WITH ROSETTE WELD.
 - FINISH: THOROUGHLY CLEAN AND POWDER COAT LID ASSEMBLY.

QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
1	36204-10	06	PLACARD BRACKET			
1	84263-01	05	LID HANDLE PROVISIONS ASSEMBLY			
2	49216-01	04	SPACER			
A/R	3/4 - 16F	03	MESH	MILD STEEL	COMMERCIAL	
A/R		02	SQUARE TUBE	4130 STEEL COND. N	MIL-T-8736	0.75 X 0.035 SQR TUBE
	94012-01	01	LID ASSEMBLY			

LIST OF MATERIALS

APPROVALS		DATE		
DRAWN: R. RATHWELL		05 AUG 11		
CHECKED: E. BURGON				
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:				
DECIMALS			ANGLES	
X.XXX ±0.010			±1/2°	
X.XX ±0.03				
X.X ±0.1				

AERO DESIGN LTD.			
8888A MALASPINA ROAD POWELL RIVER, BC, CANADA, V8A 0G3 TEL: 854 485.5370 www.aerodesign.ca			
EUROCOPTER AS350 & AS355 SERIES QUICK RELEASE CARGO BASKET LID ASSEMBLY (EXTRA LARGE)			
SCALE 1:4	DWG SIZE	DWG NO.	REV.
SHEET 1 OF 1	A1	94012	1





Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: KLAS3SD LED No. of pieces: 2

Manufacturer: AERO DESIGN

Part No.: 94012-01 Serial / Batch No.: _____

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2014-57

Remaining Tasks to be Performed: POWDER COAT

Signature: _____

Date: August 14, 2014 Lic. No. / ACA A000

In Process



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: XL A5350 BODY

No. of pieces: 2

Manufacturer: AERO DESIGN

Part No.: 94011-01

Serial / Batch No.: _____

TTSN: N/A

TSO: N/A

Rem.: N/A

Work Order No.: 2014-57

Remaining Tasks to be Performed: POWDER COAT

Signature: _____

Date: August 14, 2014

Lic. No. / ACA A506

In Process